

Work Order ID 80757-1

February-28-12 1:18:26 PM

80757

Page 1

Item ID: D4406-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 28/02/2012 Start Qty: 4.00

Required Date: 13/03/2012 Req'd Qty: 4.00

Reference:

4
4

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

QC:

Date: 12/02/28 Tooling:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4406

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg D4406-3

prog rev: 1

dwg rev: 1

0.00

B12-3-5

2-Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-5

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80757

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80757

Page 1

Item ID: D4406-043

Revision ID:

Item Name: Aft Wearplate Assembly

Start Date: 28/02/2012 Start Qty: 4.00

Required Date: 13/03/2012 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

NS1

NS2

NR1

NR2

Sequence ID/
Work Center ID

120

120

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

0.00

0.00

SP 12/03/08

8.760368

130

130

Small Fab

Small Fab

Memo

Form as per dwg D4406

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80757

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80757

Page 3

Item ID: D4406-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 28/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Large Fab

Memo

0.00

Weld bar as per dwg

A/R 2059b hardcoat Batch#: M121175

Weld bar to wearplate as per dwg

A/R s.s. rod Batch #: M120013

③ MAL 12/04/04

160

160

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

QC9

Memo

0.00

12.04.05

3x Ø

PTO

170

170

Small Fab

Small Fab

Memo

0.00

Apply coating as per dwg D4406

8120858

8.2/4/05

③

12-4-5 ③

W/O: 80757-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.04.05	160	Change to Qc 69		12.04.11			
12/04/05	#165	ADD Qc 6 inspection					

Part No: D4406-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80757

February-28-12 1:18:26 PM

80757

Page 4

Item ID: D4406-043

Revision ID:

Item Name: Alt Wearplate Assembly

Start Date: 28/02/2012 Start Qty: 4.00

Required Date: 13/03/2012 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

3 BL 12-4-5.

190

Identify as per dwg & Stock Location: FP-1

0.00

190

Packaging

Memo

0.00

Packaging

3x p 12/10/09

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/4/10 *[Signature]*
MF
12-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

February-28-12 1:18:30 PM

Page 1

Work Order ID: 80757

Parent Item: D4406-043

Parent Item Name: Aft Wearplate Assembly

80757

D4406-043

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev A 11.06.06 new issue EC verified by:DD
12.02.06 as per dwg revPBI DD ver:EC

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	252.5050	2.92	12.29474			
M304S18GA									**				
304/316 .050 Sheet													

13-2-3-5

Location

Loc Qty

Loc Code

MAT020

252.505

119032

10.3

119383

96

119766

0.205

120243

26

120604

120

150

Each

2.0000

2

8

**

119383

(4)

D4407-3

Manufactured No

D4407-3

Bar

B 82185 x 6

Location

Loc Qty

Loc Code

ENG

-8

79074

2

WA

10

(6)

MAL 12/04/04

W/O:		WORK ORDER CHANGES					
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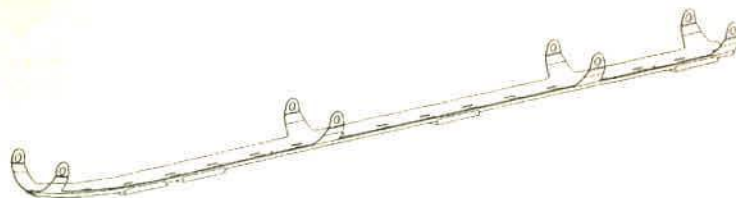
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

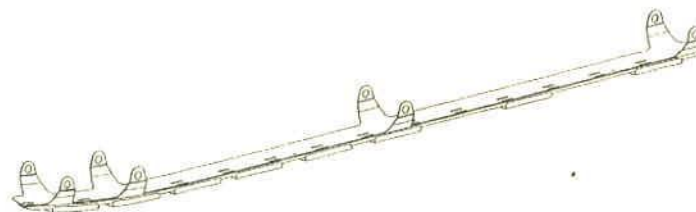
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NOTE: Date & initial all entries



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

80757 MLJ

12/02/28

RELEASE
2012-02-23
MD

B	REVISE BILL OF MATERIAL; ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3; MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4406	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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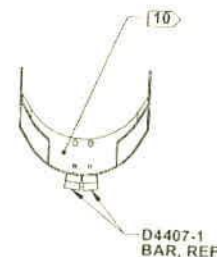
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-041 FWD WEARPLATE ASSY

SECTION A-A C3-2
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.40 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

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2012-02-23

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MFG. APPR		D4406	SHEET 2 OF 6
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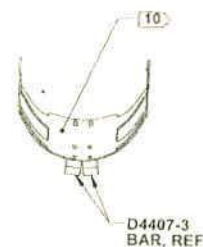
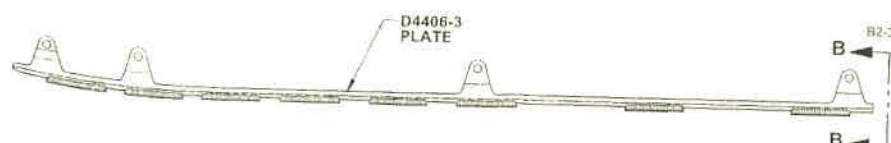
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-043 AFT WEARPLATE ASSY

SECTION B-B C3-3
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.73 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER \varnothing 0.188 HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.		D4406	SHEET 3 OF 6
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RELEASE
2012-02-23

80757

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

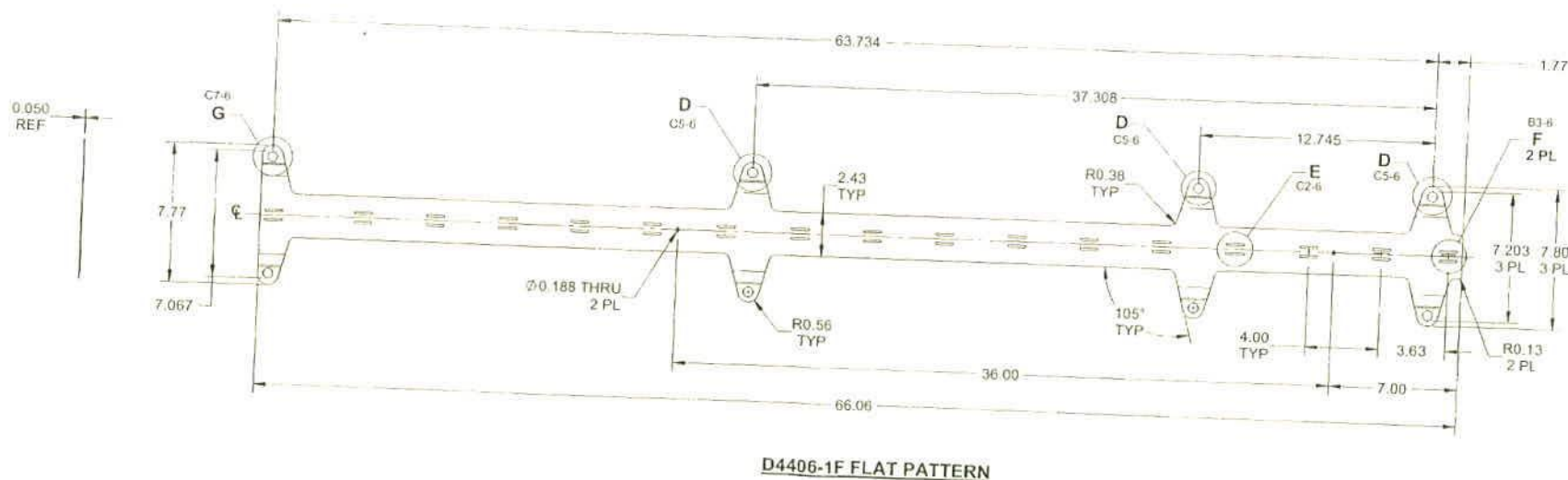
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80757



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.7 lbs

RELEASED
2012-02-23
Jm

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4406	REV. B
MFG. APPR.		TITLE WEARPLATE ASSY	SHEET 4 OF 6
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DATE	12.02.16		

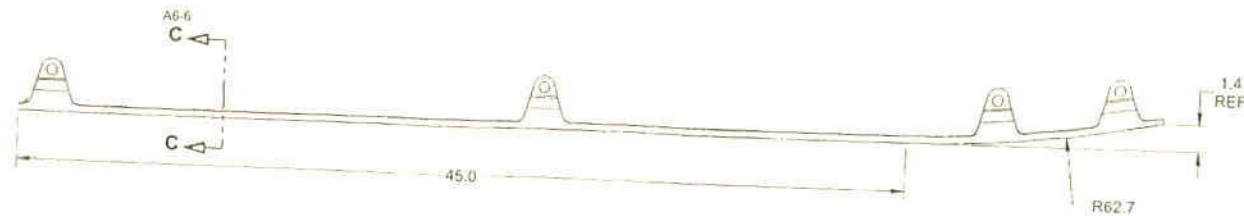
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

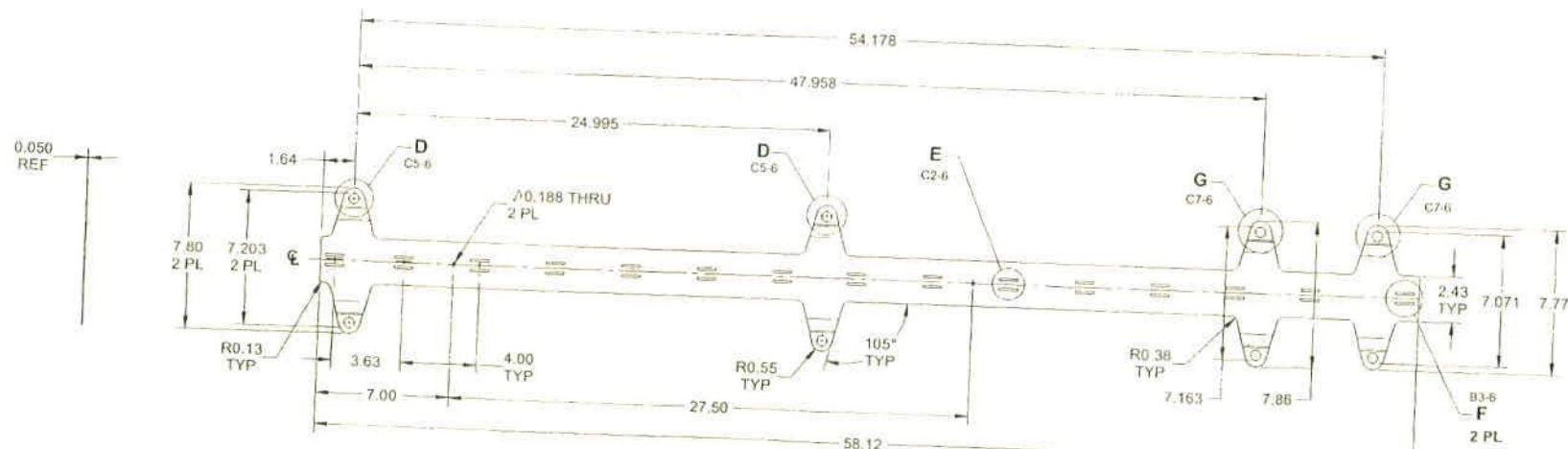
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-3 PLATE
(MAKE FROM D4406-3F)



D4406-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs

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R 2012-02-23

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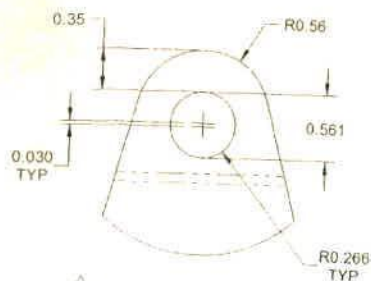
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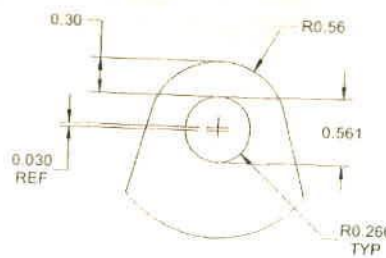
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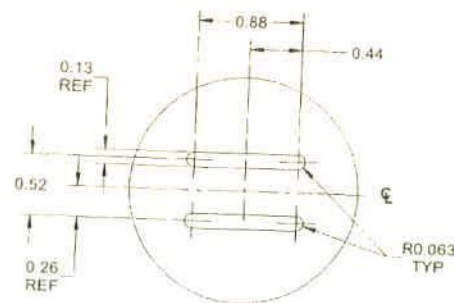
NOTE: Date & initial all entries



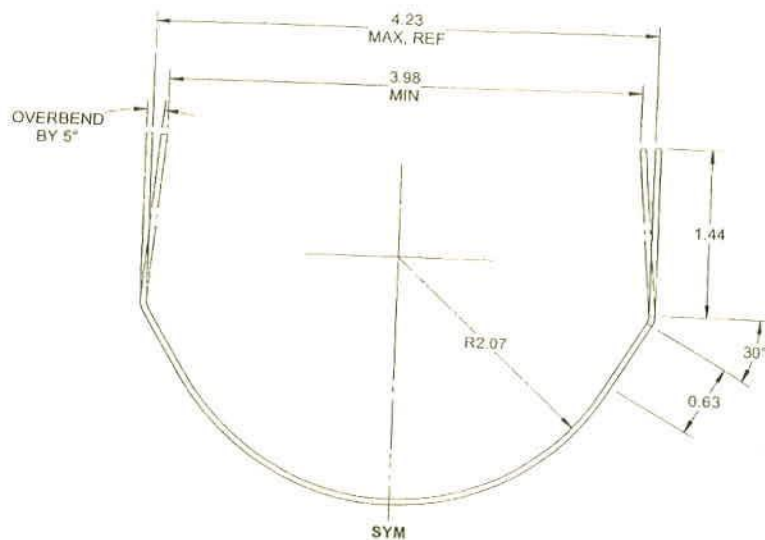
DETAIL G
SLOT DETAIL TYP
SCALE 6X



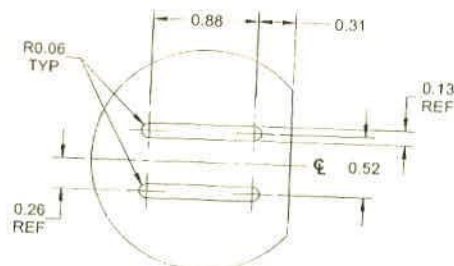
DETAIL D
SLOT DETAIL TYP
SCALE 6X



DETAIL E
SLOT DETAIL TYP
SCALE 6X



DETAIL C
DETAIL TYP
SCALE 6X



DETAIL F
SLOT DETAIL TYP
SCALE 6X

RELEASED
2012-02-23
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 6 OF 6
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries